

AI 500 Work Order ID 71859

Wednesday, July 13, 2011 11:01:07 AM



Page 1

| | | | | | | |
|----------------|-----------|------------|-------|-------|---------------|--|
| Item ID: | D2809 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Bushing | | | | | |
| Start Date: | 7/14/2011 | Start Qty: | 40.00 | | Cust Item ID: | |
| Required Date: | 7/28/2011 | Req'd Qty: | 40.00 | | Customer: | |
| Reference: | | | | | | |

| | | | | | | | | | | | |
|------------|---------------|-----------|-------|-----------------|------------|--|-------|--|-----|-------|--|
| Approvals: | Process Plan: | <u>MF</u> | Date: | <u>11-07-13</u> | Tooling: | | Date: | | Run | Start | |
| | QC: | | Date: | | SPC (Y/N): | | Date: | | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2809 | Rev A1 | | | | | | | | |

| | | | | | | | | | |
|-----|--------------------------|----------------------------|------|--|--|--|--|--|--|
| 100 | | Hardinge CNC LATHE SMALL | 0.00 | | | | | | |
| | Hardinge | Memo | 0.00 | | | | | | |
| | Hardinge CNC Lathe Small | Machine as per Folio FA204 | | | | | | | |

| | | | | | | | | | |
|-----|-----------------|---|------|--|--|--|--|--|--|
| 110 | | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | |
| | QC | Memo | 0.00 | | | | | | |
| | Quality Control | | | | | | | | |

| | | | | | | | | | |
|-----|-----------------|-----------------------------------|------|--|--|--|--|--|--|
| 120 | | QC8- Inspect parts - second check | 0.00 | | | | | | |
| | QC | Memo | 0.00 | | | | | | |
| | Quality Control | | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 71859

Wednesday, July 13, 2011 11:01:07 AM



Page 2

Item ID: D2809

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 7/14/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 140 HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | 40 | 6 | del u107/29 | |
| 160 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | 40 | 16 | 11-7-29 | |
| 170 Packaging Packaging | Identify as per dwg & Stock Location <u>023</u> Memo | 0.00 0.00 | | | | | | | 4/17/29 |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Work Order ID 71859

Wednesday, July 13, 2011 11:01:07 AM



Page 3

Item ID: D2809

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 7/14/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11-07-29
H6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 13, 2011 11:01:04 AM

Page 1

Work Order ID: 71859



Parent Item: D2809

Parent Item Name: Bushing


Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP ☐ C ☐ 02.03.07 ☐ Now turned in house ☐ NG ☐

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6R0.500  6061-T6 Round Bar .500" | | Purchased | No | | | 100 | f | 71.0220 | 0.0995 | 4.189474 | | | |



SL 1127/28

Location

MAT012

Loc Qty

71.022

Loc Code

114488

4.322

117379

66.7

7.5 84

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

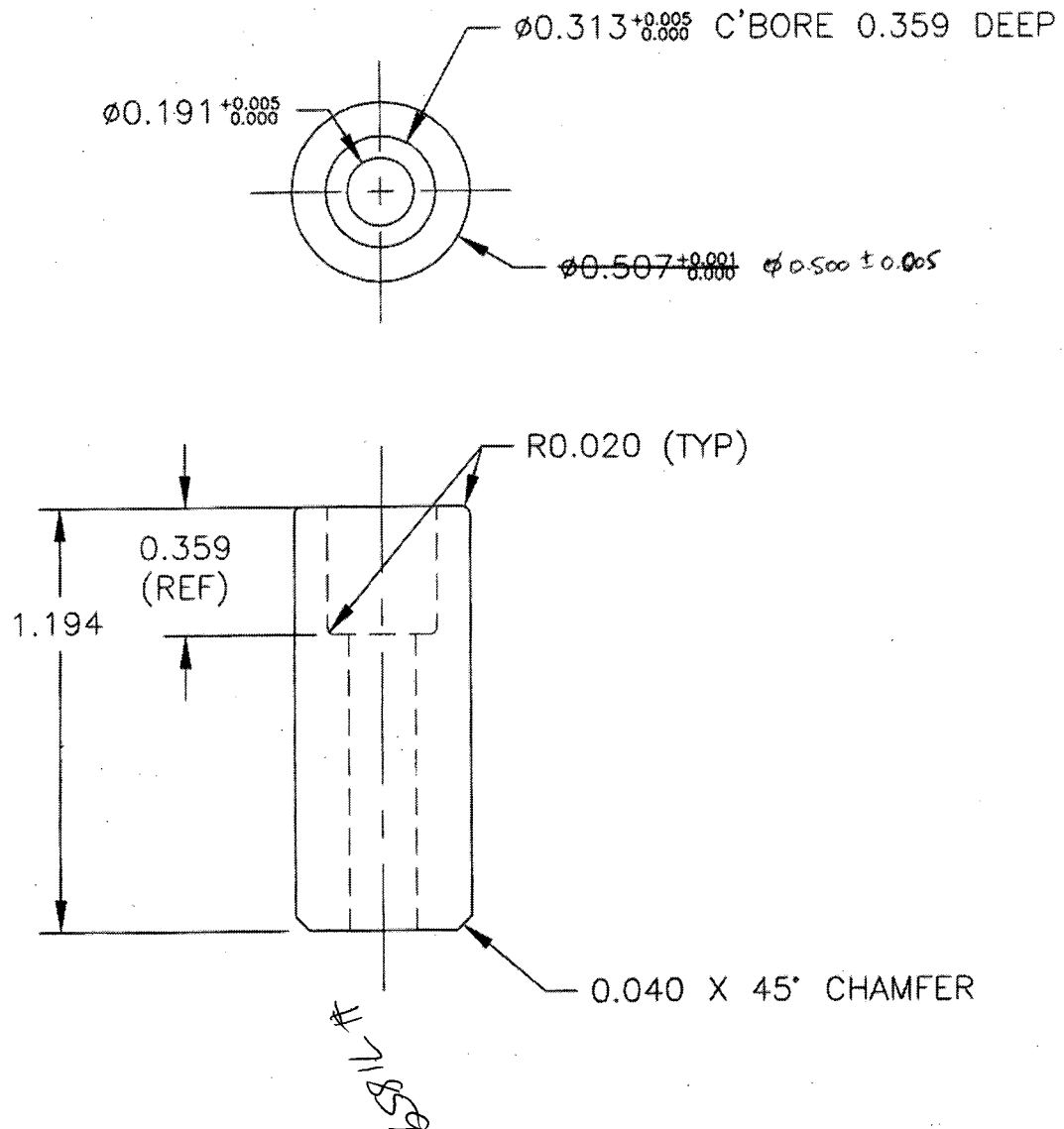
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NOTE: Date & initial all entries



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|------------------|---------------|---|------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D2809 | REV. A SHEET 1 OF 1 |
| DATE 00.11.07 | | TITLE SPACER | SCALE 2:1 |
| A | 00.11.07 | NEW ISSUE | |
| A1 | # CP 01.04.26 | ADD POWDER COAT; $\phi 0.500$ WAS $\phi 0.507$ | |

RELEASED
00.11.13



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

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PER DART QSI 005 4.3

| W/O: | | WORK ORDER CHANGES | | | | | |
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